Work Order IE August-23-13 9:27:41			*105	5885*						Page 1
tem ID: D223: Revision ID: . Item Name: Basket	2-1 Hinge		Accept	*N900	040	100)* s	Setup Star	I VI	S1* S2*
Start Date: 8/23/1 Required Date: 9/06/1 Reference:	~ ,	, , ,		Cust Item I Customer:	D:					
	ess Plan: <u>M</u>		Tooling: _ SPC (Y/N):		ate:		F	tun Star Stop		R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D2232	Rev C									
*100 *100* Waterjet FLOW CNC Waterjet 304 + 125	FLOW WATER JET Memo 1-Cut as po Deburr if n		0.00 0.00 Prog Rev.	2-			24	_0_		Jm3-08-28
*110 *110* QC Quality Control	QC2- Inspect parts off a	nachine FAI/FAIB	0.00				_2 <u>4</u> _	_0		Jm13-08-26
120 *1 2 0^*	QC8- Inspect parts - sec	cond check	DAS 27 0.00 9-89	1 9		·	24			· ———

Quality Control

												DQA:		ate:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UPI	DATE		04.61			
							-		·			QA Closed:	L	ate:	
Work Ord	er:					DISPOSITION				AGAINST I	DE	PARTMENT,	/PROCESS		
Part I	No.					Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Je d. Eng. Coo re/Packagin Supplie	r. g	Engineering Quality Other
Root					Descri	ption of work order update	T	Initial	Act	ion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	CH	nief Eng	Descr	ription		Date	Verificati	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
							FAUI	LT CATE	GORY						<u> </u>
Landi	ng (Bending				General Bend		Grain		[Ovalized			Pressure/Forced
		Centre Not Concentric to O/S BOM/Ro Cracks Broken/ Crushed/Crimped Burrs			BOM/Route Broken/Damaged Burrs Contamination		Inspecti	lardware nspection Incomplete nstructions Incomplete/Unclear			Over/Under Part Incorred Part Lost/Mi Part Moved	ct		Temperature/Cure Weld Wrong Stock Pulled	
		Heat Trea	at			Countersink	1	Mislabe		ļ		Positioned V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i	Į		Power Loss/:	-		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 105885 August-23-13 9:27:41 AM					Page 2							
Item ID: Revision ID: Item Name:	D2232-1 Basket H		A	Accept	*N900	040	100)*	Setup	Start Stop	*N:	S1*
Start Date: Required Date: Reference:	8/23/13	Start Qty: 20.00 Req'd Qty: 20.00			Cust Item Customer:						IV.	.7/
Approvals:	Process	Plan:	Date:	Tooling:	D	ate:	_		Run	Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I 130 *130* Packaging Packaging	D	Memo	Stock Location: WF 604	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	Qty		Reject Number	Insp. Stamp
140 *140* QC		QC21- Final Inspection Memo	n - Work Order Release	0.00						3/9	13	10
Quality Control										6.08	135	

												DQA:	Dat	е.	
NCR:	⁄es	/ No				WORK ORDER NON-	COI	VFORI	MANCE / UP	DATE			-		
												QA Closed:	Dat	e:	
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part No				Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other		
Root		-			Descri	ption of work order update		nitial	Ac	tion	-	Sign &			
Cause	ł	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	,	QC Inspector
Doc/Data															
Equip/Tooling															
Operator					<u> </u>										
Material															
Setup														ı	
Other															
Process							1								
Supplier															
Training															
Unapproved			1												
		•	• · · · · · · ·			F	AUL	T CATE	GORY						
Landi	ng C	Gear		•		General						_	_		
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorrec	t [Weld
	Cracks Broken/Damaged					Instruct	ions incomplete/	Unclear		Part Lost/Mi	ssing	\neg	Wrong Stock Pulled		

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Part Moved
Positioned Wrong

Power Loss/Surge

Other

Contamination

Countersink

Cut Too Short Drill Holes

Drawing Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Picklist Print

August-23-13 9:27:44 AM

Work Order ID: 105885

105885

Parent Item: D

D2232-1

D2232-1

Parent Item Name:

Basket Hinge

Start Date: 8/23/13

Required Date: 9/06/13

Page 1

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPPB01.06.07Now laser cutEC

IPP Rev:C Now on Waterjet 06-11-21 JLM

Component Item 1D/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No	· · · · · · · · · · · · · · · · · · ·		100	sf	285.6933	0.0243	0 .51157 9)		
M304S11	GA								** _	1.00		In	1308-28

												DQA:	L	vate.	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	AANCE / UP	DATE					
						•			<u></u>		_	QA Closed:		ate:	
Work Ord	er.					DISPOSITION				AGAINST D	Œ	PARTMENT,	/PROCESS		
TOTA OLG						Rework	٦		Skid-tube	Crosstube	\neg		Water Je	et 🗀	Engineering
Part I	Nα					Scrap	1		Machining	Small Fab	\dashv	Pro	d. Eng. Coo	_	Quality
, , ,						Use-as-is	1	1	noforming	Finishing			re/Packagin	_	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite	\neg	·	Supplie	_	1 📑
	,					· -	_		• 🗀	` •		•			·
Root			1		Descri	ption of work order update		Initial	Act	tion		Sign &			
Cause		Date	Step	Qty	4	or Non-conformance	Cł	nief Eng	Desci	ription		Date	Verificat	ion	QC Inspector
Doc/Data															
Equip/Tooling	L	,	1	ļ											
Operator		,		j											
Material															
Setup	╙						Ì						i		
Other	ļ		}												
Process	<u> </u>						Ì				ļ				
Supplier															1
Training	\vdash							٠			1				
Unapproved			<u> </u>	i											
 						· · · · · · · · · · · · · · · · · · ·	FAU	LT CATE	JURY		_		<u> </u>		
Landi	ng (1			_	General Bend		Grain		Г	_	Ovalized			Pressure/Forced
	<u> </u>	Bending Centre N	at Canca	ntric to	~ <u> </u>	BOM/Route	\vdash	Hardwa	.	 -		Over/Under	toloranco	\vdash	Temperature/Cure
	\vdash	Cracks	or conce	וונוונ נט	U/3 -	Broken/Damaged	\vdash	- 	on incomplete	<u> </u>	_	Part Incorre		-	Weld
	\vdash	Cracks Crushed/	Crimned		<u> </u>	Burrs		┥	on incomplete/lions Incomplete/l	inclear –	_	Part Lost/Mi		\vdash	Wrong Stock Pulled
	\vdash	Crusnea/	Сипреа		-	Contamination	-	Mainte	•	Unclear		Part Moved	3311 1 B	<u> </u>	Tanonia stock ranea
	\vdash	Heat Trea	at		-	Countersink	\vdash	Mislabe		1	_	Positioned V	Vrong		
		Inspectio		Tube		Cut Too Short	\vdash	Misread		<u> </u>	_	Power Loss/	_		Other
						1 				I .			•	1	1

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

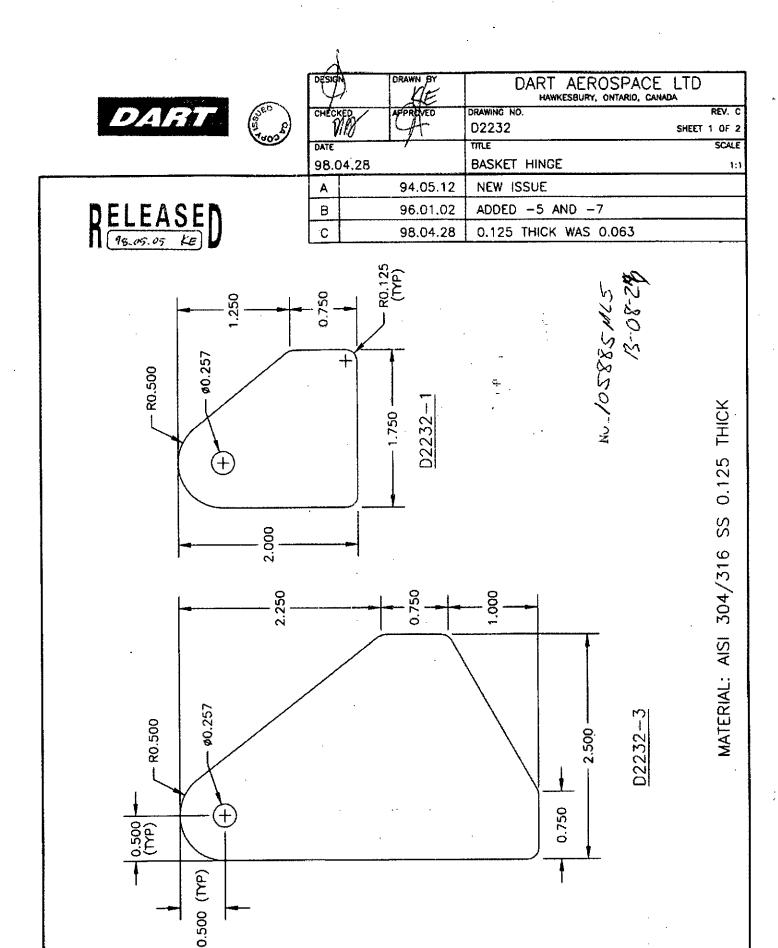
Folio

DART AEROSPACE LTD	Work Order:	105885
Description: Basket Hinge	Part Number:	D2232-1
Inspection Dwg: D2232 Rev: C		Page 1 of 1

	FIRST	ΓARTICLE II	NSPECTI	ON CHE	CKLIST		
	X	First Arti	cle	Prote	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Cor	nments
Ø0.257	+0.006/-0.001	<i>).</i> २५४°			V	Thron	
1.750	+/-0.010	1.754"	_		υ		
0.750	+/-0.010	0753	-		V		
2.000	+/-0.010	2.004	_		V		
R0.125	+/-0.010	0.125	_		Ro		
R0.500	+/-0.010	0.500			RG		
1.250	+/-0.010	1.251			V		
					<u></u>		
					<u></u>	<u> </u>	
		<u> </u>					
						_	
			DAS				
Measured by:	Im	Audited by:	9-89	-	Prototype A	pproval:	N/A
Date:	13-08-28	Date:	13-8	29		Date:	N/A

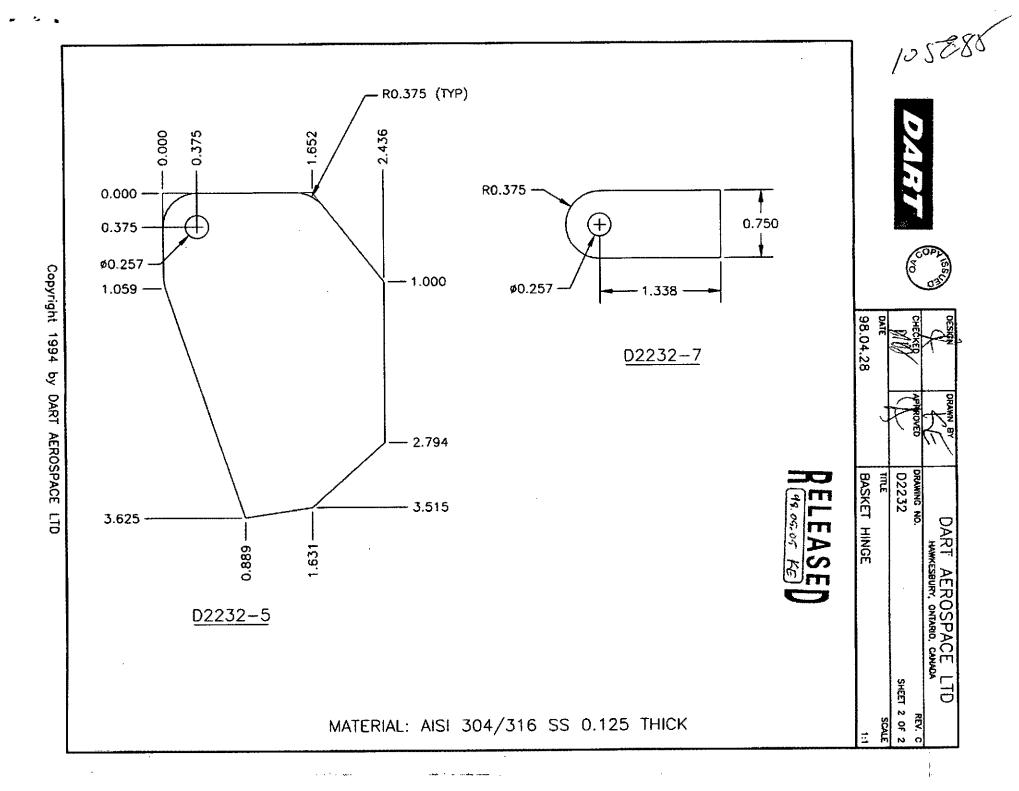
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM A	B

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